

Date: Thursday, 02/10/2008 8:24:07 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 42382	
Estimate Number : 13107	
P.O. Number :	Part Number : D3719041
This Issue : 02/10/2008 S.O. No. :	Drawing Number : D3719 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 42041	Material :
Written By :	Due Date : 10/10/2008 Qty: 24 Um: Each
Checked & Approved By : <u>JD 08.10.07</u>	
Comment : Est Rev :A New Issue 07-12-19 EC verified by DD	
Est Rev:B 08-09-25 add QC5 DD verified by:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.5933 sf(s)/Unit Total: 14.2380 sf(s)

304/316 .060 Sheet

Batch: 108724 1B 8-10-2

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3719

Dwg Rev: A 1B 8-10-2

Prog Rev: A



2-Deburr if necessary 1B 8-10-2

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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1B 8-10-2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

8-10-10-2 427 waiters

5.0	D30093	Cup
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 96.0000 Each(s)

CUP

Batch: 841176

EL 8-10-6

1108

1108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 02/10/2008 8:24:07 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 42382

Part Number: D3719041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3719

M107051

ND7

2-Weld hard facing as per Dwg D3719

A/R 2059B Hard Coat rod

Batch:

M109213

EL 8-10-8

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/10/08

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/08

(27)

9.0

POWDER COATING

POWDER COATING



M106442



(27X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

1:50

OVEN TEMPERATURE:

320 °F

FINISH TIME:

2:20

08/10/08

M. A.

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-10-08

(22)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

STU48

SL

08/10/08

FE

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/09

Job Completion



U 08/10/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

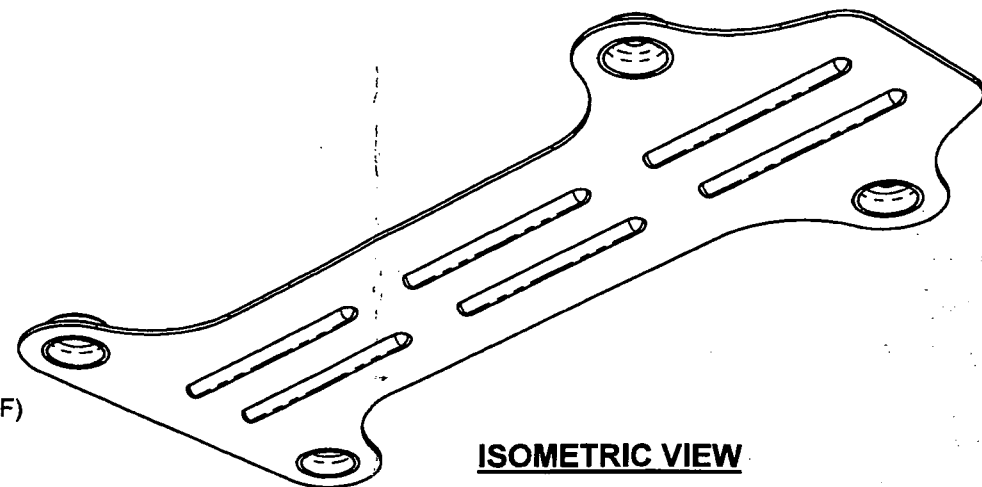
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

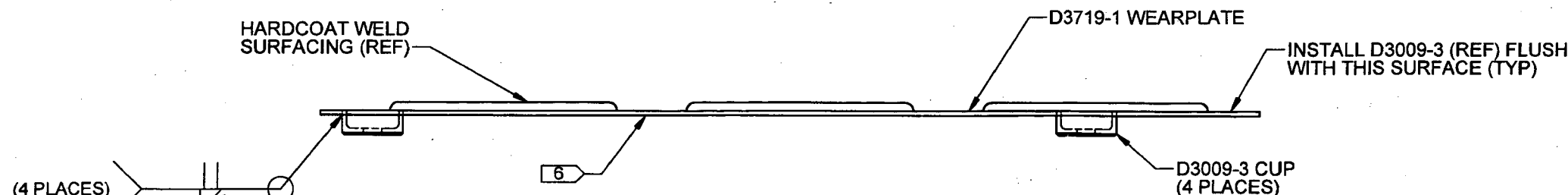
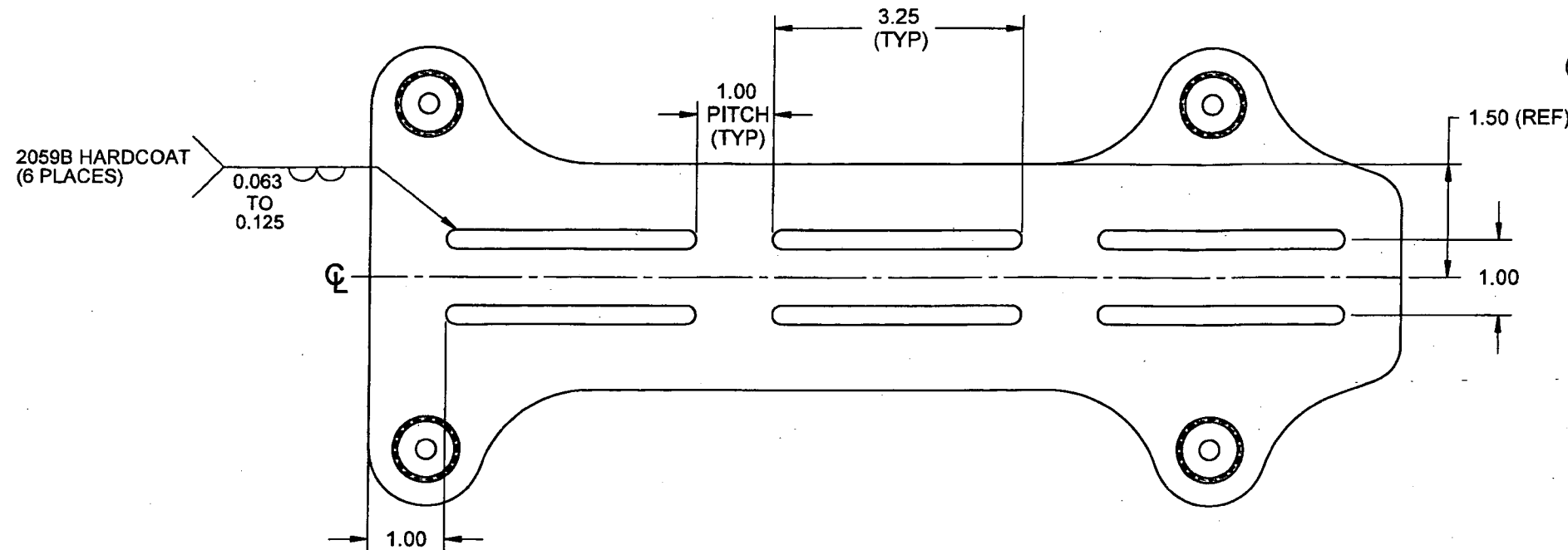
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

PARTS LIST FOR D3719-041 WEARPLATE:		
QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP



ISOMETRIC VIEW



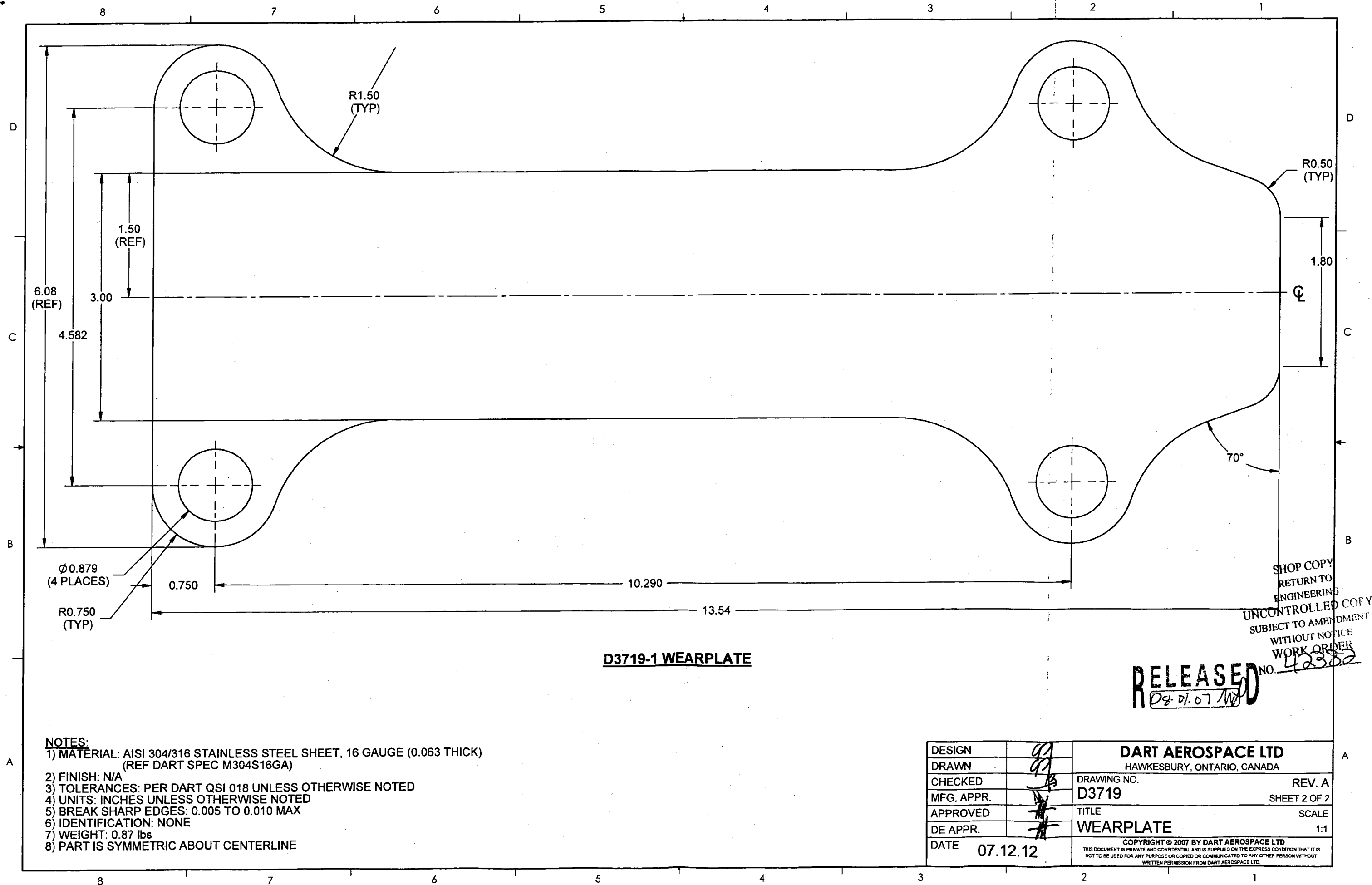
D3719-041 WEARPLATE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 4238

RELEASED  
07-01-07

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 1.11 lbs
  - 8) PART IS SYMMETRIC ABOUT CENTERLINE
  - 9) WELD PER DART QSI 004

A	NEW ISSUE	CP	07.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	g21		
DRAWN	g21		
CHECKED	g21		
MFG. APPR.	g21		
APPROVED	g21		
DE APPR.	g21		
DATE	07.12.12		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3719 TITLE WEARPLATE REV. A SHEET 1 OF 2 SCALE 1:2 COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 42382
<b>Description:</b> WEAR PLATE	<b>Part Number:</b> 3719-024-1
<b>Inspection Dwg:</b> D3719-1, <b>Rev:</b> A	Page 1 of 1


## FIRST ARTICLE INSPECTION CHECKLIST

**X**

**x**

[illegible]

Measured by:	BB
Date:	8-10-2

<b>Audited by:</b>	
<b>Date:</b>	08/10/02

Prototype Approval:	✓
Date:	7

Rev	Date	Change	Revised by	Approved
A		New Issue	P/O D3719-041 KJ/JLM	